

Date: Friday, 5/25/2007 8:16:07 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
Job Number : 32572	
Estimate Number : 10258	
P.O. Number :	Part Number : D2332041
This Issue : 5/25/2007 S.O. No. :	Drawing Number : D2332 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C1
Previous Run : 31694	Material :
Written By :	Due Date : 6/15/2007 Qty: 40 Um: Each
Checked & Approved By : <u>07.05.28</u>	
Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 K J/RF	

## Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description:
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1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

M 104 862 (37)

M 103 987  
 M 104 593  
 M 104 489  
 M 104 640

Batch

M 104 582

2.0	M304R250	1/4" 304 SS Roundbar
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Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)

Material: Ø0.250" 304SS Rod

Batch M 104 128

(x37)

07-07-30

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

(x37)

(38) 07-07-30

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s)

304 RD Tube .500 x .035W

M 104 862 (37)  
 M 103 987 19  
 M 104 593 2  
 M 104 489 13  
 M 104 640 9

(x37)

8B 07/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	App QC Insp

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32572

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012  
(Note: Make (2) D2332-11 Prop Arms per assembly.)

*ml 07/07/30 x37*

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M104721

*ml 07/07/30*

*07/07/31 (37)*

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 01-02-31 (37)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Er 07/07/31 x37*

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

*ml 07/08/01*

*x37*

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~20.0000~~ Each(s) **37x**

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M101291

*✓ ml*

Dart

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~60.0000~~ Each(s) **111X**

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M104214 X3  
M104236 X108

✓  
ml

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~20.0000~~ Each(s) **37X**

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M102552

✓  
ml 07/08/01

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

208 01

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

2 Assy in CA  
35 store

ml 07/08/01

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.02  
JH

Job Completion



ml 07.08.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

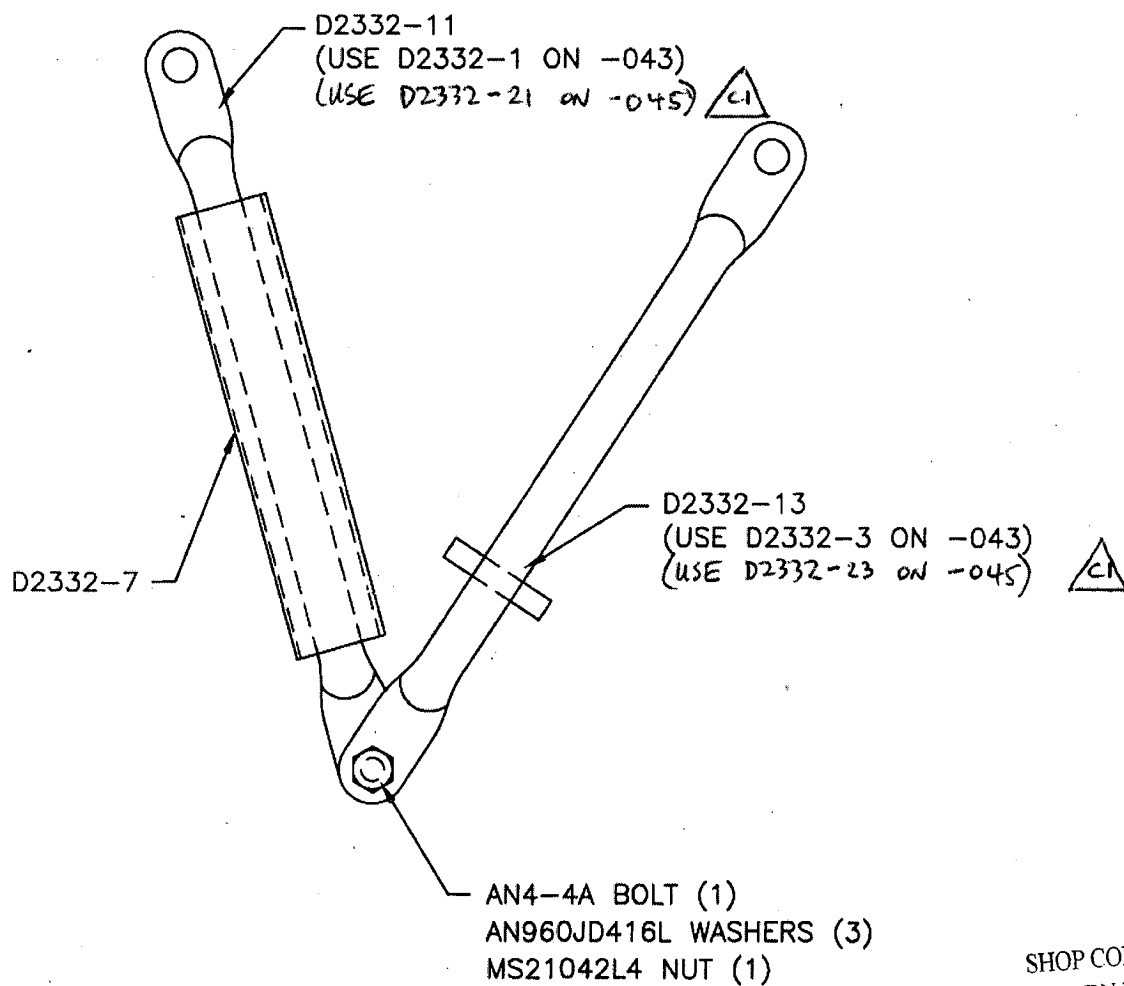
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	# 40 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED  
03.07.04



D2332-041 SHOWN  
(D2332-043 SIMILAR)  
(D2332-045 SIMILAR)  $\triangle$  C1

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NO. 32572

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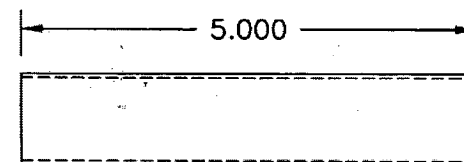
4431

W. J. L. J.

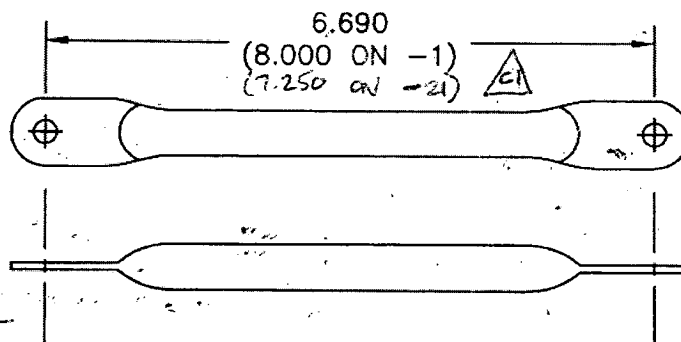
**DART**

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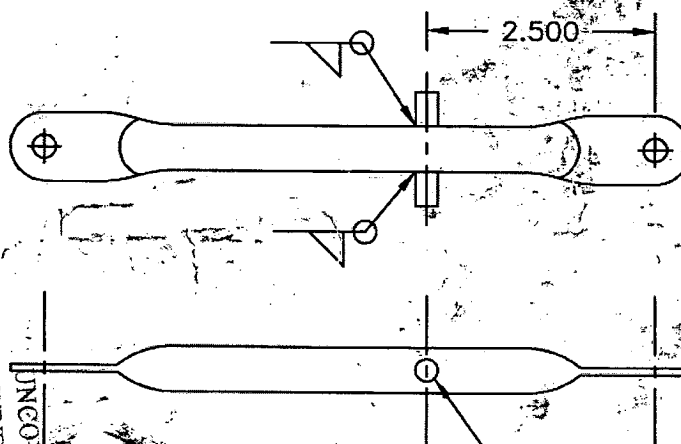
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE - 0.1" PROP 6.69" LONG (CTD)
C1	03.08.06	MAKE - 0.43" PROP 8.00" LONG (OM)
		ADD - 0.45" PROP 7.25" LONG



D2332-7 LOCKING COLLAR



D2332-11 PROP  
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13

M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5  
D2332-23 SIMILAR - M/F D2332-21 & D2332-5

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED  
03.01.04

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NO. 32572

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